

Date: Friday, 09/05/2008 1:45:19 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT ASSEMBLY		
Job Number	: 39152					
Estimate Number	: 10732					
P.O. Number	:			Part Number	: D23241	
This Issue	: 09/05/2008		S.O. No.	: D2324 REV. C		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 36749			Drawing Revision	: C	
Written By	:			Material	:	
Checked & Approved By	<u>JULY 08.5.09</u>			Due Date	: 05/06/2008	
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K			Qty:	20	Um: Each
	J/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :				
1.0	39152A	STOP				
		Comment: Sub-Component STOP D2324-3 B 36749A		<i>CB08/05/12</i>		
2.0	39152B	STRAP				
		Comment: Sub-Component STRAP D2324-5 B 37631		<i>CB08/05/12</i>		
3.0	AN312A	Bolt				
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s) Bolt M103947 (7x) M106605 33x <i>CB08/05/12</i>				
4.0	AN960JD10	Washer				
		Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s) Washer M107715 <i>CB08/05/12</i>				
5.0	MS21042L3	Nut				
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s) Nut M107644 <i>CB08/05/12</i>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:45:19 PM
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Drawing Name: STRUT ASSEMBLY

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D23241.

08/05/12 20

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S08/05/12 20

8.0 POWDER COATING

POWDER COATING



m/07550

Pb →

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:50

OVEN TEMPERATURE: 320

FINISH TIME: 11:20

F 08/05/13 20

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

18 S 08/05/14 420

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 203

18 08/05/14 20

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/15 AF

Job Completion



W 08/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

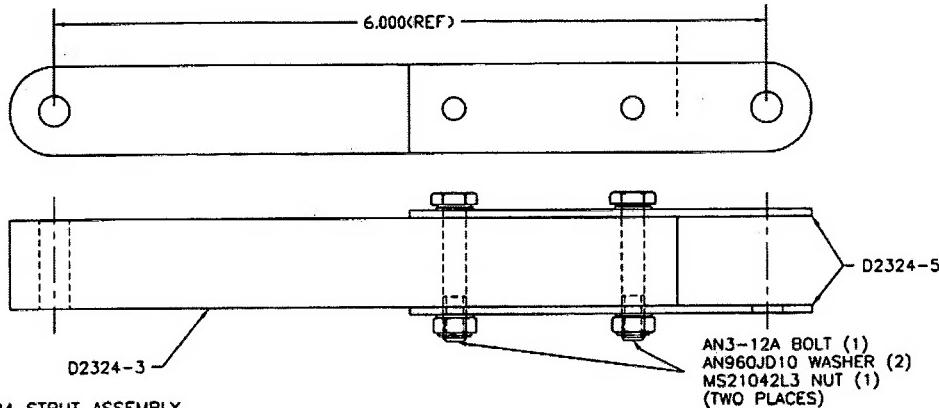
Part No: D2324-1 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: S Date: 08/05/15
 QA: N/C Closed: S Date: 08/05/15

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/13	# 8.0 C/S b/w	During Powder coat inspection it was found that one strut has a loose scratch on it.	S/P Initial	Re Pull out scratch Re alot alot affected area Alodine Start time: 2:25 Temp: 320° Finish time: 2:55 Re Powder coat AS ref QSI005	S/P 08/05/13 08/05/13 08/05/13 08/05/13 08/05/13	08/05/13 08/05/13 08/05/13 08/05/13 08/05/13	S/P Initial	S/P 08/05/13
			S/P Initial	FR A N3 - 12 A M 106(605) 2 AN 9600010 FR M S 21042 L3 M 107(64 Remove and Replace Hardware	S/P 08/05/13	08/05/13 08/05/13	S/P Initial	S/P 08/05/13

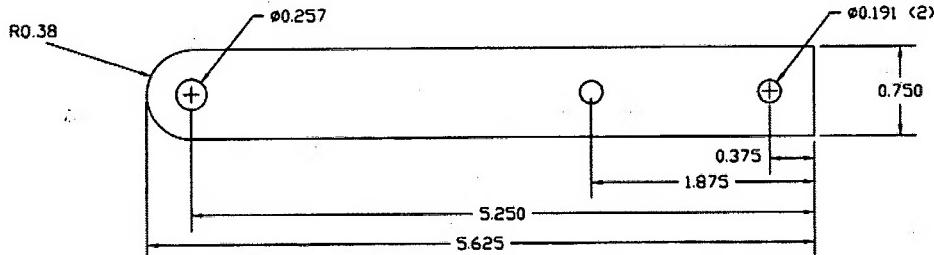
NOTE: Date & initial all entries

DART

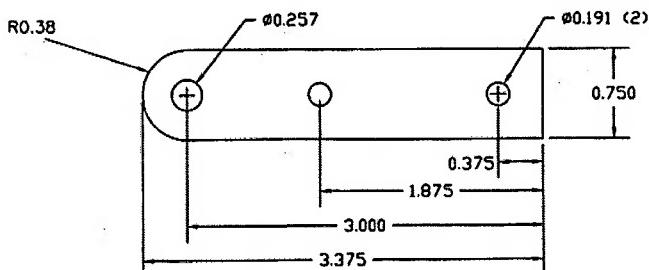
DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324	REV. C SHEET 1 OF 1
DATE 04.12.14		TITLE STRUT	SCALE

RELEASED04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 (REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO *39150*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries